



Dart Aerospace Ltd.
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K6A 1K7
Canada

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D2884

Job Sheet 181208



Part No: D2884

Job Qty: 24 ea

Part Name: Saddle Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/24/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP A 99.10.12 New Issue EC IPP Rev:B Now 6061-T6 06-06-23 JLM IPP Rev:C Now on Waterjet 06-08-23 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	24 Ea	8/31/18	8/31/18	0.00	0.00	Start Up Waterjet		OK 18/08/18
100	Waterjet	24 pcs	8/31/18	8/31/18	0.00	0.67	Waterjet1		OK 18/08/18
120	QC	24 pcs	8/31/18	8/31/18	0.00	0.00	QC8		AUG 15 2018
130	HandFinish	24 pcs	8/31/18	8/31/18	0.00	0.80	HandFinish1		OK 18/08/18
140	QC	24 pcs	8/31/18	8/31/18	0.00	0.00	QC7-1		AUG 16 2018
150	Packaging	24 pcs	8/31/18	8/31/18	0.00	0.00	Packaging3		AUG 17 2018
160	QC21-SA	24 Ea	8/31/18	8/31/18	0.00	0.00	QC21		AUG 20 2018

Part Op Descriptions: 100 - 1-Cut as per Dwg D2884 2-Tumble ,Deburr if necessary

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.080	6061-T6 .080 Sheet	1.5144 sf (.0631 ea)	90-Start up Operation	5099480

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.080	2	27	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle Spacer	0.257Inches + 0.006 - 0.001	0.263 0.256	Diameter	
2	Saddle Spacer	0.430Inches ± 0.030	0.460 0.400		
3	Saddle Spacer	1.646Inches ± 0.010	1.656 1.636		
4	Saddle Spacer	3.427Inches ± 0.010	3.437 3.417		
5	Saddle Spacer	0.521Inches ± 0.010	0.531 0.511		
6	Saddle Spacer	0.250Inches	0.280		

QA Closed: _____ Date: _____

Work Order update only



WORK ORDER NON-CONFORMANCE / UPDATE

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS																																																		
Part No. _____		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																															
NCR No. _____		Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																															
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																															
		Rejected/Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐																																																
Date : _____								MRB (QSI042) Approval																																														
DART AEROSPACE Container No: S101436 Part: D2884 Job No: 181208 Serial No/Batch: S101436 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Uart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaero.com Date: 08/13/18								Completed By																																														
								Lead hand / Supervisor Approval Verification																																														
								QC / QA Coordinator Approval																																														
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	OTHER : _____	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐

		+ 0.030	0.250
		- 0.000	
7	Saddle Spacer	4.730Inches ± 0.030	4.760 4.700
8	Saddle Spacer	0.800Inches ± 0.030	0.830 0.770
9	Saddle Spacer	0.521Inches ± 0.010	0.531 0.511
10	Saddle Spacer	0.855Inches ± 0.010	0.865 0.845
11	Saddle Spacer	0.847Inches ± 0.010	0.857 0.837

Plex 7/24/18 9:19 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								